



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-742-041
Job Sheet 178428



Part No: D412-742-041

Job Qty: 1 ea

Part Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) & OEM Cyl. Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3391-041 REV J SHEETS 1,2 IPP Rev A 05.10.13 New Issue KJ/JLM IPP Rev 06.02.13 ECN 773 dwg
@ rev.D EC IPP Rev:C 07-05-28 As per Rev F JLM IPP rev D 07.11.01 ecn 1053p EC IPP rev E 07.11.27 ecn
1072 EC verified:DD IPP Rev:F 08-09-08 ecn 08-510 DD verified:EC IPP Rev:G 10.02.24 as per ECN10-514
DD verified: EC IPP Rev:H 11.11.01 as per DSI9517 REV.B DD verified:EC IPP REV:I 16.05.02 AS PER DWG
REV.J DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/15/18	6/15/18	0.00	0.00	Start Up Container		JUL 18-7-19
110	HandFinish	1 pcs	6/15/18	6/15/18	0.00	3.77	HandFinish4		JUL 18-7-19
120	QC	1 pcs	6/15/18	6/15/18	0.00	0.00	QC5		JUL 18-7-19
125	DC	1 pcs	6/15/18	6/15/18	0.00	0.00	DC		JUL 18-7-19
130	Packaging	1 pcs	6/15/18	6/15/18	0.00	0.00	Packaging3-2		JUL 18-7-19
140	QC21-FG	1 Ea	6/15/18	6/15/18	0.00	0.00	QC21		JUL 18-7-19

Part Op 110 - 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with
Descriptions: saddle holes for proper alignment. using 7/16" "T" Pins. A/R Sikaflex-241/-291 _____ Expiry date:
2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped
with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no
sikaflex. A/R Sikaflex-241/-291 _____ Expiry date: _____ 3-Remove "T" pins once sikaflex is dry.
4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon

125 - If D412-742-041 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-041 CHG007

130 - Identify and pack for shipping as per PPP D412-742-041 Location : FG073

Job BOM

004496

Part / Item	Component Name	Quantity	Operation	Container
AN3C4A	Bolt	24 Ea (24 ea)	90-Start up Operation	5068642
AN3C6A	Bolt	4 Ea (4 ea)	90-Start up Operation	5076000
AN5C7A	Bolt	10 Ea (10 ea)	90-Start up Operation	5076007
D3391-011	Fwd Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5036926
D3391-013	Mid Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5076857
D3391-015	Aft Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5079230
D3672-3	Washer, Phenolic	4 Ea (4 ea)	90-Start up Operation	F132639
D4095-041	Wearplate Fwd	1 Ea (1 ea)	90-Start up Operation	F164512-1
D4095-043	Wearplate Aft	1 Ea (1 ea)	90-Start up Operation	5059995
D4095-045	Wearplate Center	1 Ea (1 ea)	90-Start up Operation	5041027
MS27039C4-12	Screw	4 Ea (4 ea)	90-Start up Operation	F124586
NAS1149C0332R	Washer	28 Ea (28 ea)	90-Start up Operation	5056493
NAS1149C0432R	Washer	4 Ea (4 ea)	90-Start up Operation	5050052-1
NAS1149C0532R	Washer	10 Ea (10 ea)	90-Start up Operation	5014735

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C4A	24	1,908	0
	AN3C6A	4	434	0
	AN5C7A	10	144	0
	D3391-011	1	1	0
	D3391-013	1	0	0
	D3391-015	1	0	0
	D3672-3	4	1,355	0
	D4095-041	1	18	0
	D4095-043	1	21	0
	D4095-045	1	15	0
	MS27039C4-12	4	153	0
	NAS1149C0332R	28	6,681	0
	NAS1149C0432R	4	2,195	0
	NAS1149C0532R	10	315	0

Part Specifications

Specifications could not be found.

Plex 5/31/18 12:49 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S093479



Part: D412-742-041

Job No: 178428

Serial No/Batch: S093479

Revision: A/J

Inspector:

Exp Date:

Instructions:

1675 Highway 100
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/19/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :					